

BLUE

Dart Aerospace Ltd.

23

Date: Wednesday, 5/16/2007 8:14:40 AM  
User: Kim Johnston

## Process Sheet

SPLIT-2

Customer : CU-DAR001 Dart Helicopters Services  
Job Number : 32383 -2  
Estimate Number : 10939  
P.O. Number : N/A  
This Issue : 5/16/2007 S.O. No. : N/A  
Prsht Rev. : NC  
First Issue : N/A Type : MACHINED PARTS  
Previous Run : 30481  
Written By :  
Checked & Approved By : James K  
Comment : Est: B 00.06.26 New DWG rev (mpp 2069) EC  
Est Rev: C As per Rev C 07-03-19 JLM

Drawing Name : 206/OH-58 SADDLE, INBOARD, RIGHT SIDE - UNDER REVIEW  
Part Number : D29382 WP  
Drawing Number : D2938 REV C  
Project Number : N/A  
Drawing Revision : C  
Material : N/A  
Due Date : 6/6/2007 Qty: 12 Um: Each

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6101003 7075-T7351 2X6.25X7.875



Comment: Qty.: 1.0000 Each(s)/Unit Total : 16.0000 Each(s)

Issue material from stock: 7075-T7351 (QQ-A-250/12)

Cut Size 2.0" x 6.25" X 7.88" Grain Along 7.88" Length

(D6101-003)

Batch No: B31387 mk 07/06/20 (12)

2.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Program part number and batch number.

1-Inspect part number and batch number are programmed correctly.

2-Machine Step No 1 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet

3-Machine Step No 2 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet

4-Machine Step No 3 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet

5-Deburr

mk 07/06/20 (12)

3.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

mk 07/06/20 (12)

4.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

mk 07/06/20 (12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/07/11

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 5/16/2007 8:14:40 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE - UNDER  
REVIEW

Job Number: 32383

Part Number: D29382

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.L 07/07/03

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M-k

07/07/04

(12X)

7.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

-PRIME

-PAINT DELFLEET BLUE

-CLEAR DELFLEET

N/A

8.0

QC14

INSPECT SPRAY PAINT



Comment: INSPECT SPRAY PAINT

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 57447

stock unpacked

07/17/04 (12) UP

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(12) 07/07/04

Job Completion



W.A.O.A. 11



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	32383
<b>Description:</b> 206 Saddle, Outboard, Right side	<b>Part Number:</b>	D2938-2
<b>Inspection Dwg:</b> D2938 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		0.127	0.128	0.128	0.128		
B	0.100	0.140		0.127	0.127	0.127	0.128		
C	0.100	0.140		0.117	0.115	0.116	0.117		
D	0.210	0.230		0.225	0.225	0.225	0.225		
E	1.245	1.255		1.250	1.250	1.250	1.249		
F	1.245	1.255		1.249	1.250	1.250	1.249		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		0.510	0.510	0.510	0.510		
I	1.572	1.582		1.576	1.577	1.577	1.576		
J	2.495	2.505		2.499	2.499	2.500	2.500		
K	0.257	0.262		0.258	0.258	0.258	0.258		
L	0.312	0.317		0.314	0.314	0.314	0.314		
M	0.235	0.240		0.239	0.239	0.239	0.239		
N	0.100	0.140		0.119	0.119	0.120	0.119		
O	0.540	0.560		0.546	0.550	0.550	0.550		
P	0.490	0.510		0.500	0.500	0.500	0.502		
Q	3.715	3.725		3.717	3.717	3.717	3.717		
R	2.720	2.760		2.744	2.742	2.743	2.743		
S	0.240	0.270		0.254	0.254	0.255	0.255		
T	0.100	0.180		0.138	0.142	0.138	0.146		
U	1.625	1.635		1.628	1.628	1.628	1.628		
V	1.362	1.372		1.366	1.366	1.366	1.366		
W	0.316	0.321		0.320	0.320	0.320	0.320		
X	1.250	1.270		1.260	1.260	1.259	1.259		
Y	1.565	1.585		1.576	1.576	1.575	1.573		
Z	0.178	0.198		0.188	0.188	0.188	0.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	<i>[Signature]</i>
Date:	07/07/02

Audited by:	<i>[Signature]</i>
Date:	07/07/02

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	<i>[Signature]</i>



<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	32383
<b>Description:</b> 206 Saddle, Outboard, Right side	<b>Part Number:</b>	D2938-2
<b>Inspection Dwg:</b> D2938 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		0.128	0.127	0.128	0.128		
B	0.100	0.140		0.128	0.128	0.128	0.128		
C	0.100	0.140		0.118	0.118	0.118	0.118		
D	0.210	0.230		0.224	0.225	0.225	0.225		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.249	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.499		
H	0.510	0.515		0.510	0.510	0.510	0.510		
I	1.572	1.582		1.576	1.576	1.576	1.576		
J	2.495	2.505		2.501	2.499	2.500	2.499		
K	0.257	0.262		0.258	0.258	0.258	0.258		
L	0.312	0.317		0.314	0.314	0.314	0.314		
M	0.235	0.240		0.238	0.239	0.238	0.238		
N	0.100	0.140		0.117	0.118	0.118	0.119		
O	0.540	0.560		0.551	0.548	0.547	0.548		
P	0.490	0.510		0.502	0.500	0.502	0.500		
Q	3.715	3.725		3.717	3.717	3.717	3.717		
R	2.720	2.760		2.743	2.743	2.744	2.743		
S	0.240	0.270		0.255	0.255	0.256	0.255		
T	0.100	0.180		0.146	0.146	0.141	0.141		
U	1.625	1.635		1.628	1.628	1.628	1.628		
V	1.362	1.372		1.366	1.366	1.366	1.366		
W	0.316	0.321		0.326	0.326	0.320	0.320		
X	1.250	1.270		1.260	1.259	1.258	1.259		
Y	1.565	1.585		1.573	1.574	1.573	1.574		
Z	0.178	0.198		0.188	0.188	0.188	0.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	CML
Date:	07/07/02

Audited by:	JL
Date:	07/07/03

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	



<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 32383
<b>Description:</b> 206 Saddle, Outboard, Right side	<b>Part Number:</b> D2938-2
<b>Inspection Dwg:</b> D2938 Rev. C	Page 1 of 1

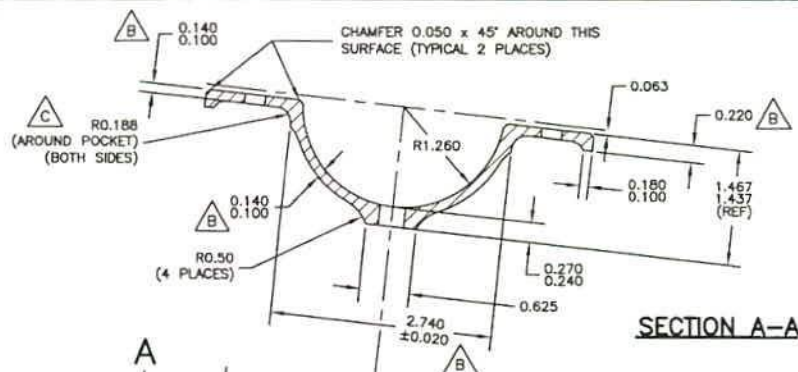
Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
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C	0.100	0.140		0.120	0.118	0.116	0.120		
D	0.210	0.230		0.225	0.225	0.225	0.225		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.499	2.500		
H	0.510	0.515		0.510	0.510	0.510	0.510		
I	1.572	1.582		1.577	1.577	1.576	1.576		
J	2.495	2.505		2.500	2.500	2.500	2.499		
K	0.257	0.262		0.258	0.258	0.258	0.258		
L	0.312	0.317		0.314	0.314	0.314	0.314		
M	0.235	0.240		0.239	0.239	0.239	0.239		
N	0.100	0.140		0.119	0.119	0.119	0.119		
O	0.540	0.560		0.547	0.546	0.550	0.546		
P	0.490	0.510		0.502	0.506	0.503	0.502		
Q	3.715	3.725		3.717	3.717	3.717	3.717		
R	2.720	2.760		2.744	2.743	2.743	2.742		
S	0.240	0.270		0.256	0.256	0.255	0.257		
T	0.100	0.180		0.140	0.140	0.140	0.140		
U	1.625	1.635		1.628	1.628	1.628	1.628		
V	1.362	1.372		1.366	1.366	1.366	1.366		
W	0.316	0.321		0.326	0.326	0.326	0.320		
X	1.250	1.270		1.259	1.259	1.259	1.258		
Y	1.565	1.585		1.574	1.574	1.574	1.572		
Z	0.178	0.198		0.188	0.188	0.188	0.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

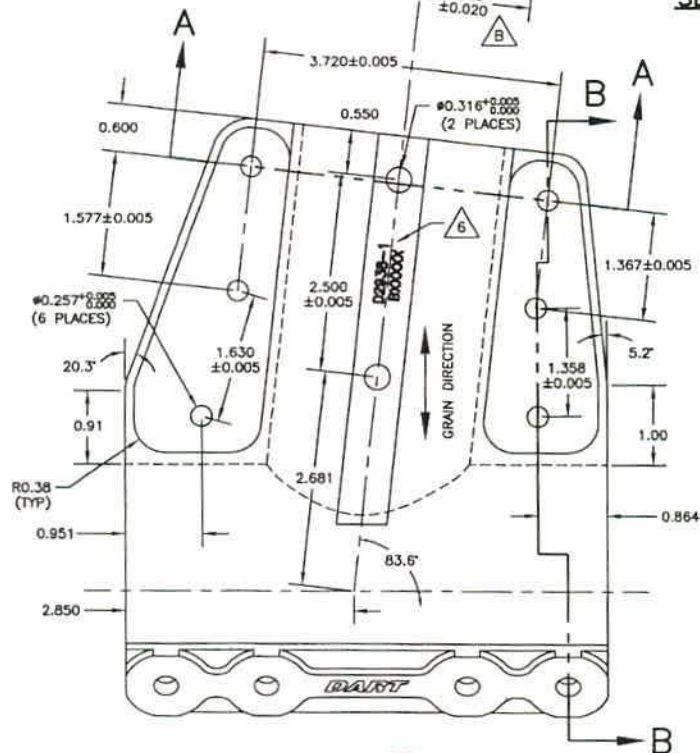
Measured by:	JWL
Date:	07/07/03

Audited by:	JL
Date:	07/07/03

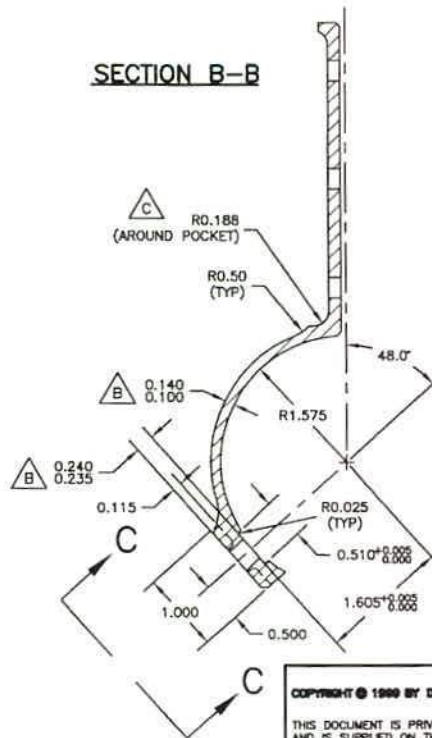
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
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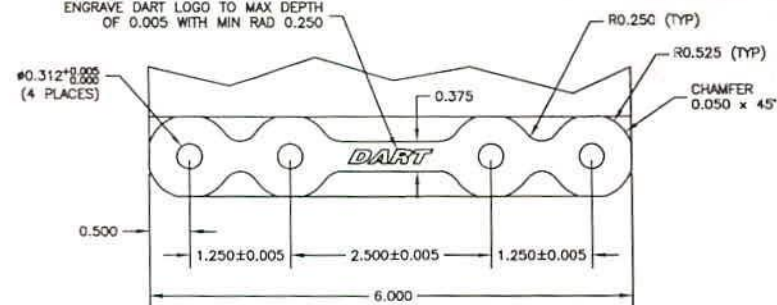
SECTION A-A



SECTION B-B



ENGRAVE DART LOGO TO MAX DEPTH OF 0.005 WITH MIN RAD 0.250



VIEW C-C

D2938-1 LH SADDLE (SHOWN)  
D2938-2 RH SADDLE (OPPOSITE)

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)  
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE
DESIGN	DRAWN BY	<b>DART</b> DART AEROSPACE USA, INC. BELLINGHAM, WA
CHECKED	APPROVED	DRAWING NO. D2938
DATE	TITLE	REV. C SHEET 1 OF 1 SCALE 2:3
06.11.09	SADDLE OUTSIDE	

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07.02.12

NO. 32383  
WORK ORDER  
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WITHOUT NOTICE